



Dart Aerospace Ltd.
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D119-796-151
Job Sheet 169660-C



Part No: D119-796-151

Job Qty: 1 ea

Part Name: Fwd Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/18/17

Job Tracking No:

Due Date: 12/29/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D119-796-151 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP
REV:D 15-02-11 AS PER REV D JLM VERIFIED BY:DD IPP REV:E 17.12.11 REMOVE PICK KIT DD
VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/28/17	0.00	0.00	Start Up Crosstubes-1		✓ [Signature] DEC 22 2017
130	Crosstubes	1 pcs		12/29/17	0.00	0.49	Crosstubes-1		✓ [Signature]
140	QC	1 pcs		12/29/17	0.00	0.00	QC5		✓ [Signature] 17.12.22
145	DC	1 pcs		12/29/17	0.00	0.00	DC		
150	Packaging	1 pcs		12/29/17	0.00	0.00	Packaging3-1		✓ [Signature] DEC 22 2017
160	QC21-FG	1 Ea		12/29/17	0.00	0.00	QC21		

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-151 ***Torque all clamps to 50 IN-LBS max.***
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***
145 - Photocopy bluefile and create labels as per PPP D119-796-151 chg 004
150 - Identify and pack for shipping as per PPP D119-796-151

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D119-796-141 165702	①	10	0	0
	D5123-3 5006028	④	419	0	0
	D5149-041 5011230	②	7	0	0
	MS21920-22 5013763	④	98	0	0

Part Specifications

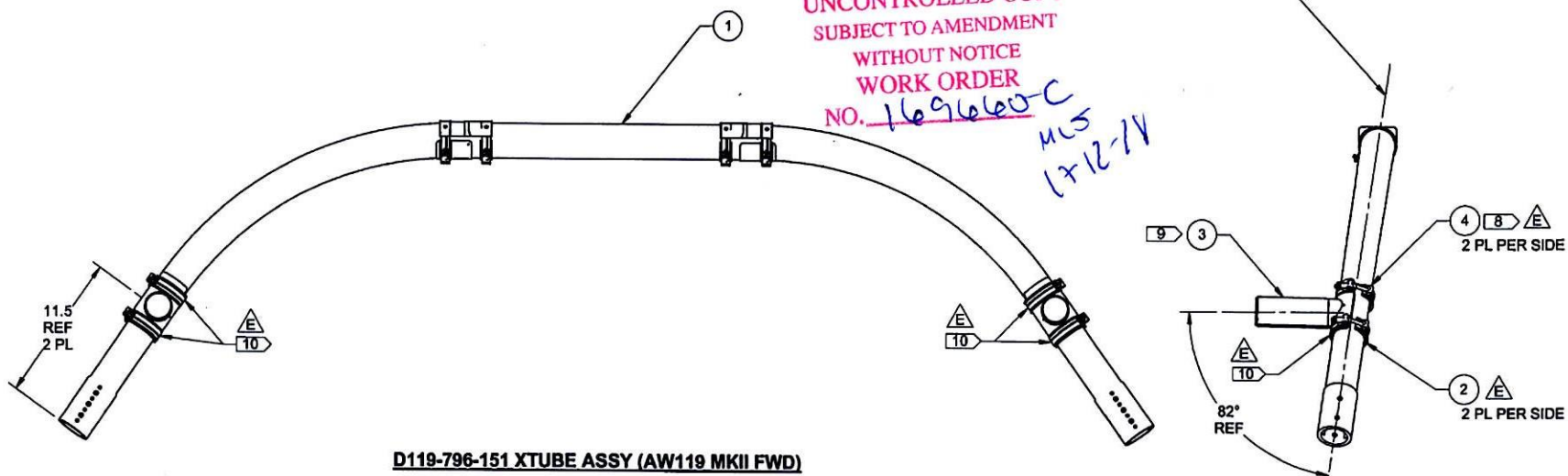
Specifications could not be found.

Plex 12/18/17 10:50 AM Dart.lajeunesse.marie

ITEM	QTY	P/N	DESCRIPTION
	-151		
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11691660-C
MCS
17-12-14

D119-796-141 XTUBE
BENDING PLANE



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

NOTES:

- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
 - 7) WEIGHT: 20.01 lbs
 - 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
 - 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
 - 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN.
- THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10 (PAR16-527) UPDATE WEIGHT DUE TO -141 CHANGE	ML	17.02.10
D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C8A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-151 REV. E SHEET 1 OF 1 TITLE XTUBE ASSY (AW119 MKII FWD) SCALE NTS	
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	DP		
APPROVED	WM		
DE APPR.	DS	DATE 17.02.10	

RELEASED
2017-05-04
ECN 17-538

APPROVED

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								